

Date: Tuesday, 12/11/2007 8:22:52 AM
 User: COSS Admin

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 36248		
Estimate Number	: 11221		
P.O. Number	:	Part Number	: D3350041
This Issue	: 12/11/2007 S.O. No.	Drawing Number	: D3350 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 /	Drawing Revision	: A
Previous Run	: 34652	Material	:
Written By	: <u>07-12-11</u>	Due Date	: 12/18/2007 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est B 05.07.11 Powder Coat now done after assembly KJ/JL M		

Additional Product

Job Number:

Machine Or Operation:

Description:

1.0

M6061T6B0750X00750

6061-T6 Bar .75" x .75"

Comment: Qty.: 1.3234 f(s)/Unit Total: 13.2342 f(s)

6061-T6 Bar .75" x .75"

Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6B0.750x00.750)

Identify for D3350-1

Batch: M106563080107

2.0

BAND SAW

BAND SAW

Comment: BAND SAW

Cut blank: 0.750" x 0.750" x 15.00" long

080107

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE

Mill as per Dwg D3350

080111

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

080111

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

080111

(5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 36248

Part Number: D3350041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble and Deburr

CP 08/01/15 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

M-H 08/01/15

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP 08/01/16 (10)

9.0

D23245

Strap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Strap

Pick:

Qty Part Number Description Batch

2 D2324-5 Strap

35930

AS 08/01/15 (X10)

10.0

AN312A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3-12A

Bolt

M103947

AS 08/01/15 (X10)

11.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty Part Number

4 AN960JD10

Description

Batch

Washer

*Still Batch Error M105792 **

AS 08/01/15 (X10)

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

M105558

AS 08/01/15 (X10)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 36248

Part Number: D3350041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
2	MS21042L3	Nut (or -3)	

See previous step on

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3350.

Identify as D3350-041 and batch number using a fine point permanent marker

08/01/16 @

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/16 @

15.0

POWDER COATING

POWDER COATING



M106379



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FL 08/01/17 @

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/17 @

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 271*

AS 08/01/18 @

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.21

Job Completion

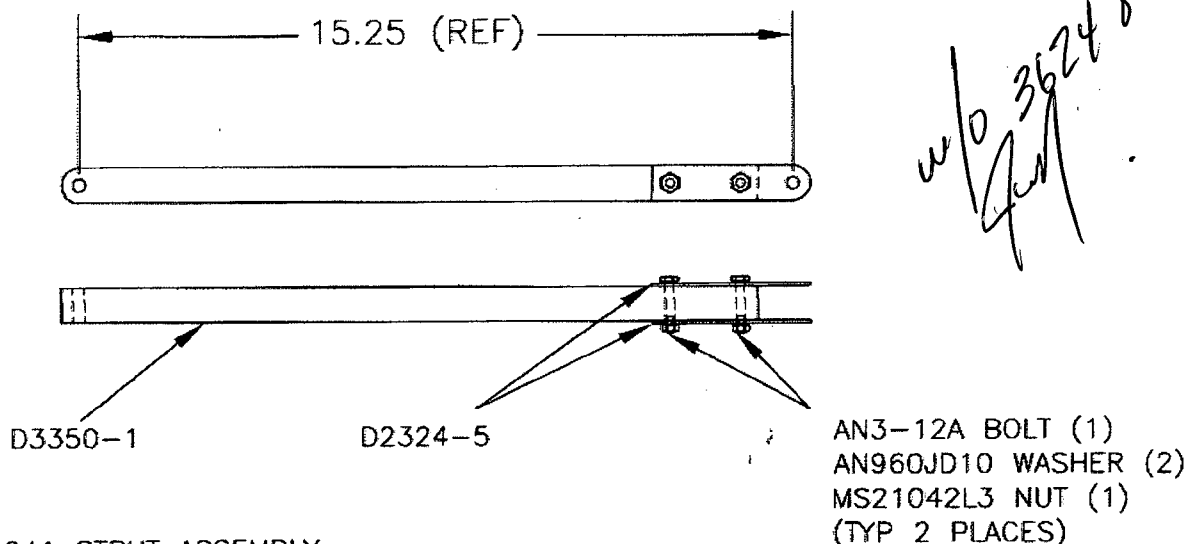


2008/1/21

W

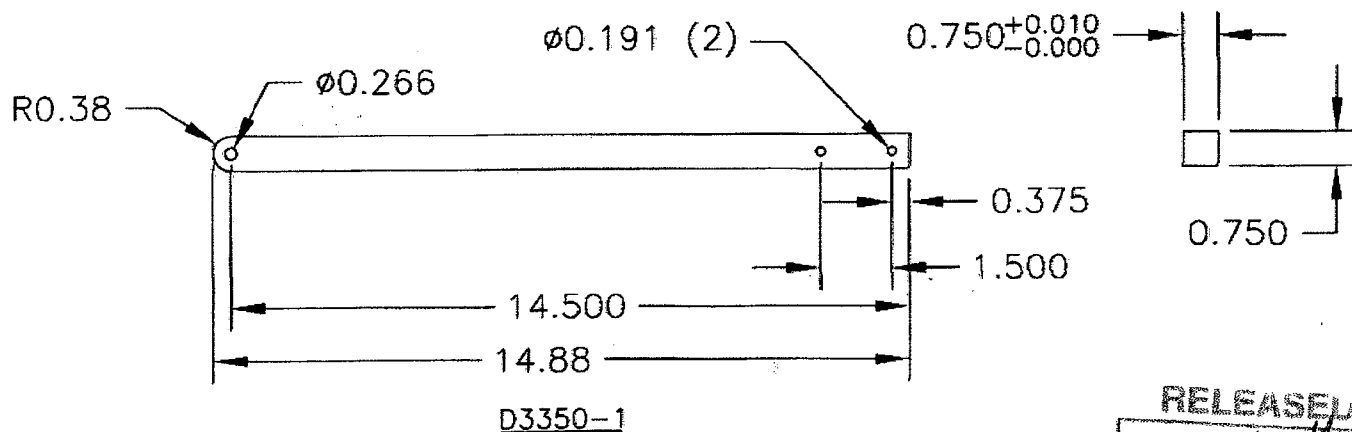


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3350	REV. A SHEET 1 OF 1
DATE 04.11.12		TITLE STRUT	SCALE 1:4
A	04.11.12	NEW ISSUE	



D3350-041 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



RELEASED

04.12.16

D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

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